Work Order ID 60010

Tuesday, June 22, 2010 3:21:56 PM

Item ID: D4043-041 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Rib Assembly

Start Date: 6/22/2010 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 7/30/2010 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** H **Date:** 10-6-22 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4043	A								
100	Weld per dwg A/R S.S. rod Batch: M10877	0.00				1			
Large Fab									
Large Fab	**Memo**	0.00							
	1- Cut D4043-1 as per dwg D4043 2- Drill and chamfer holes as per dwg D4043 3-Remove identification markings SAM 10-06-23 4- Weld bushing in rib and grind weld flush as per dwg D4043								
	1 PD 10.06.24								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

Sulocu 24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 60010

Tuesday, June 22, 2010 3:21:56 PM

Item ID: D4043-041
Revision ID:
Item Name: Rib Assembly
Start Date: 6/22/2010 **Start Qty:** 1.00
Required Date: 7/30/2010 **Req'd Qty:** 1.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: basket	0.00							
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/06/24

PD 10.06.24

10/06/24

CL 10/6/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Tuesday, June 22, 2010 3:22:02 PM

Work Order ID: 60010

Parent Item: D4043-041

Parent Item Name: Rib Assembly

Start Date: 6/22/2010 **Required Date:** 7/30/2010

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP RevA: new issue DD 10/01/05 verified by:EC IPP Rev:B as per dwg revA DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4043-9		Manufactured	No			100	Each	4.0000	1	1			
Bushing										B60057 -XD		RD 10.06.24	
				Location			**Loc Qty**		**Loc Code**				
				WA			4						
					56114		4						
M304TS0.500W.049		Purchased	No			100	f	155.2554	2.1392	2.251789			
Square Tubing										SAD	10-06-23		
				Location			**Loc Qty**		**Loc Code**				
				MAT			148.1591158						
					114004		0						
					114426		9.2647						
					114807		138.894416			2.251789			
				MAT018			4.4738						
					114004		0.5						
					114161		3.9738						
				WA			2.62251						
					114724		2.62251						

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

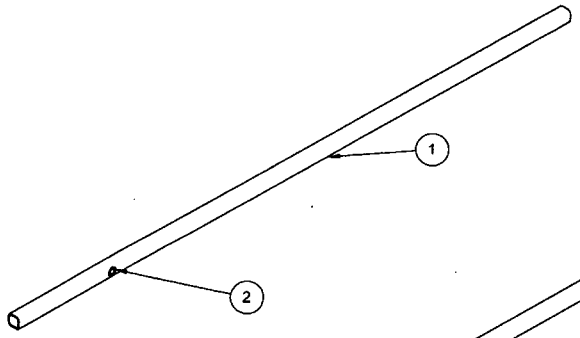
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

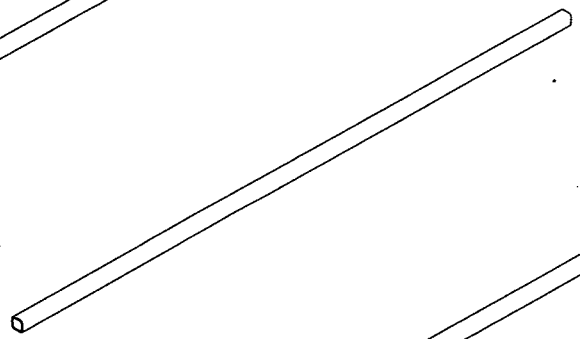
H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60010
BB 10-6-22

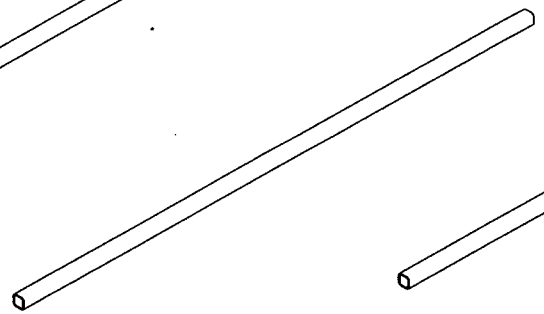
ITEM	QTY -041	P/N	DESCRIPTION
	X	D4043-041	RIB ASSEMBLY
1	1	D4043-1	RIB
2	1	D4043-9	BUSHING



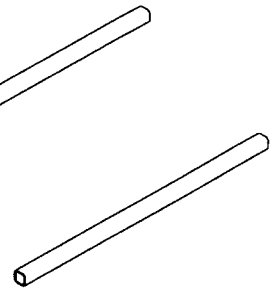
D4043-041 RIB ASSEMBLY



D4043-3 RIB



D4043-5 RIB



D4043-7 RIB

D4043-9 BUSHING

RELEASED
2010 -02- 16

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	RF	10.01.29

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D4043 — REV. A — SHEET 1 OF 4
MFG. APPR.		
APPROVED		TITLE: RIB ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	10.01.29	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

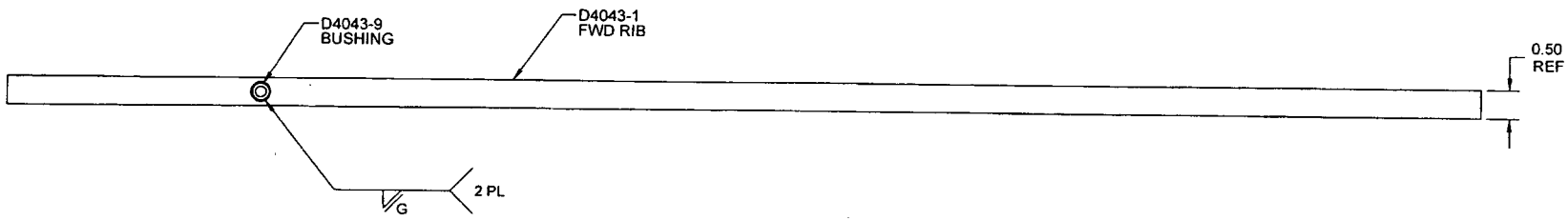
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



D4043-041 RIB ASSEMBLY

w/o 60010

RELEASED
2010 -02- 16

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 0.60 lbs
8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D4043 — REV. A — SHEET 2 OF 4
MFG. APPR.		
APPROVED		TITLE: RIB ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	10.01.29	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

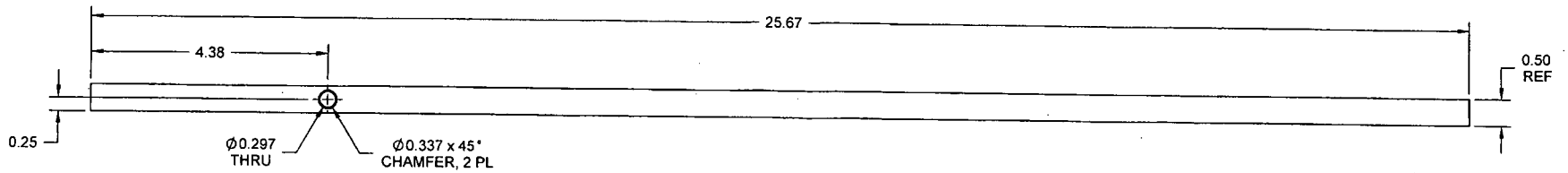
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

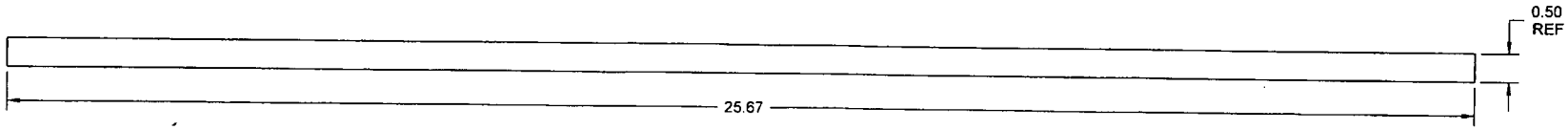
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

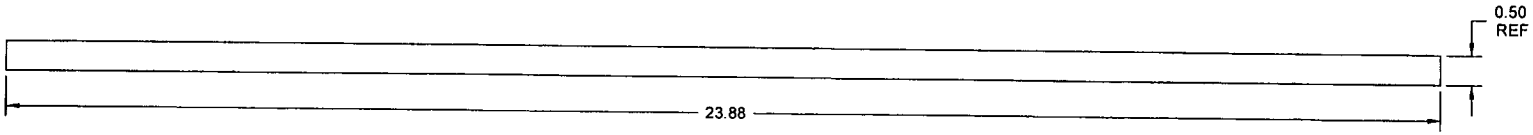
H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



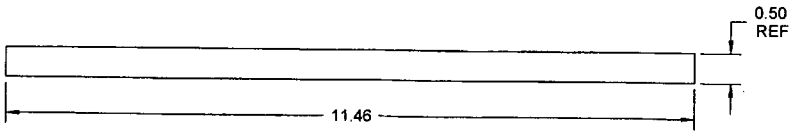
D4043-1 RIB



D4043-3 RIB



D4043-5 RIB



D4043-7 RIB

RELEASED
2010 -02- 16

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
REF DART SPEC. M304TS0.500W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D4043-1: 0.59 lbs
D4043-3: 0.59 lbs
D4043-5: 0.55 lbs
D4043-7: 0.26 lbs

w/o 60010

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4043 — REV. A
CHECKED		SHEET 3 OF 4
MFG. APPR.		TITLE: RIB ASSEMBLY — SCALE: NTS
APPROVED		
DE APPR.		
DATE	10.01.29	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

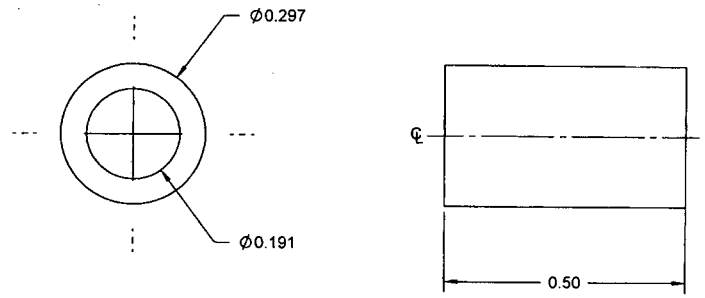
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



D4043-9 BUSHING

RELEASED
2010 -02- 16

NOTES:
1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR
REF DART SPEC. M303R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.006 lbs

w/o 60010

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D4043 — REV. A — SHEET 4 OF 4
MFG. APPR.		
APPROVED		TITLE RIB ASSEMBLY — SCALE NTS
DE APPR.		
DATE	10.01.29	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries